

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021062**Date Inspected:** 28-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wang Zhen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 13

This QA Inspector observed the following work in progress:

Holes were being threaded on back of diaphragm on steel barriers E2-SB10-048, W5-SB2-012.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld joint identified W5-SB21-001-102, located on Steel barrier joint W5-SB21-001, welder is identified as 201074, ZPMC Quality Control (QC) is identified as Mr.Wang Zhen. The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified SA3321-020-003, located on Splice Plate, identified as SA3321-020,

WELDING INSPECTION REPORT

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welder is identified as 062259, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified SA3321B-007-003, located on Splice Plate, identified as SA3321B-007, welder is identified as 05978, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified E5-SB12-002-089, located on Steel barrier joint E5-SB12-002, welder is identified as 062265, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified E5-SB12-003-059, located on Steel barrier joint E5-SB12-003, welder is identified as 203805, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay # 16

NDT

The following NDT performed ZPMC NDT notification 07954

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an MT report for this date. Time of inspection was 9:00 hours. The members are identified as follows OBG, Steel Barriers, The weld designations reviewed are as follow:

W5-SB1-078-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.
W5-SB1- 072-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 063, 065, 067, 069, 071
W5-SB1-080-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.
W5-SB1-084-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.
W5-SB1-070-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 063, 065, 067, 069, 071
W5-SB1D-017-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.
W5-SB1D-016-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.
W5-SB2-013-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.
W5-SB2-016-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 063, 065, 067, 069, 071
W5-SB20-001-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 063, 065, 067, 069, 071

OBG Bay # 16

NDT

The following NDT performed ZPMC NDT notification 07961

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an MT report for this date. Time of inspection was 15:30 hours. The members are identified as follows OBG, Steel Barriers, The weld designations reviewed are as follow:

HW-SAW-119MW(S)-1-1~4, HW-SAW-119MW(S)-2-1~4, HW-SAW-119MW(S)3-1~4,

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HW-SAW-131MW(S)1-1~4, HW-SAW-131MW(S)2-1~4, HW-SAW-131MW(S)3-1~4,
HW-SAW-123MW(S)1-1~4, HW-SAW-123MW(S)2-1~4, HW-SAW-123MW(S)3-1~4,
HW-SAW-119MW(S)1-1~4, HW-SAW-119MW(S)2-1~4, HW-SAW-119MW(S)3-1~4,

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
Reviewed By:	Hall, Steven	QA Reviewer
